

A MOLD FOR MAKING A COMPOSITE MATERIAL PART, THE MOLD  
BEING COATED IN A STRIPPING COMPOSITION

The present invention relates to a mold for making a  
composite material part, the mold being coated in a  
5 stripping composition. Although not exclusively, the  
present invention applies particularly to helicopter  
blades or to helicopter blade elements, which are usually  
manufactured by molding a composite material.

In order to make it easier to extract such blades or  
10 blade elements from the mold after polymerization, it is  
conventional initially to apply a stripping composition  
over the entire surface of the mold.

Known stripping compositions contain a large  
proportion of solvent, and as a result present numerous  
15 drawbacks, such as the large quantities that need to be  
used and the volatile organic compounds that are dumped  
into the environment.

An object of the present invention is to remedy  
those drawbacks. The invention relates to a mold coated  
20 in a solvent-free anti-adhesive stripping composition  
that is particularly effective.

To this end, according to the invention, a mold for  
making a composite material part is coated in a stripping  
composition comprising:

- 25 · 100 parts by weight of a base ingredient  
consisting in epoxy polydimethylsiloxane;
- 0.5 to 10 parts by weight of a polymerization  
agent for polymerizing the base ingredient and  
constituted by a diaryliodonium salt;
- 30 · not more than 30 parts by weight of an anti-  
adhesion modulator constituted by a silicone polymer; and
- not more than 40 parts by weight of an anti-stick  
agent making the composition less tacky prior to  
polymerization and constituted by at least one vinyl  
35 ether compound.

Preferably, the anti-adhesion modulator is also  
constituted by an epoxy polydimethylsiloxane.

As base ingredient and as adhesion modulator, it is possible to use respectively the products manufactured by the supplier Rhodia and having the following trade names respectively: UV POLY 200 and UV RCA 200. Similarly, the polymerization agent based on diaryliodonium salt can be that manufactured and sold under the trade name UV CATA 21 1 by said supplier Rhodia.

Said anti-stick agent (which serves amongst other things to enable the stripping composition to be spread easily on the walls of the mold and significantly to reduce the sticky appearance left by the epoxy polydimethylsiloxane when not polymerized) can be constituted by a mixture of a monovinyl ether and a divinyl ether.

In a preferred embodiment, the monovinyl ether is dodecyl monovinyl ether [formula  $\text{CH}_3-(\text{CH}_2)_{11}-\text{O}-\text{CH}=\text{CH}_2$ ], while the divinyl ether is 1.4 cyclohexane dimethanol divinyl ether [formula  $\text{CH}_2=\text{CH}-\text{O}-\text{C}_6\text{H}_{10}-\text{O}-\text{CH}=\text{CH}_2$ ].

Advantageously, said stripping composition adapted to the mold comprises:

- 5 to 7 parts by weight of the polymerization agent;
- 5 to 10 parts by weight of the anti-adhesion modulator, said anti-adhesion modulator being an epoxy polydimethylsiloxane; and
- the anti-stick agent being present at a concentration in the range 8 to 12 parts by weight of a dodecyl monovinyl ether and 8 to 12 parts by weight of a cyclohexane dimethanol divinyl ether.

More advantageously, the stripping composition has:

- 6 parts by weight of the polymerization agent;
  - 8 parts by weight of the anti-adhesion modulator;
- and
- the anti-stick agent being present at a concentration of 11.4 parts by weight of a dodecyl monovinyl ether and 11.4 parts by weight of a cyclohexane dimethanol divinyl ether.

Thus, by means of the invention, a solvent-free stripping composition is obtained which presents very good anti-adhesion properties, in particular because it is made on the basis of silicone. This stripping  
5 composition also presents good performance in terms of sticking behavior and painting behavior of the composite part made by molding. Because of the chemical characteristics of said composition which is based on epoxy siloxanes, the small amount that might be  
10 transferred during molding has no significant negative influence on the sticking properties or on the painting behavior of the part, contrary to that which can be observed with stripping compositions based on solvent.

It should be observed that compared with usual  
15 stripping compositions based on solvent, the composition of the invention obtained from the above-specified mixture also presents the following advantages:

- elimination of the problem of dumping volatile organic compounds;
- 20     · reduction in the quantity of composition consumed;
- reduction in the time required to apply the composition;
- improvement in the sticking characteristics on the composite material; and
- 25     · improvement in surface appearance.

The stripping composition of the invention polymerizes under the action of ultraviolet radiation or on application of heat. The polymerization cycle by heating may comprise 1 hour at 150°C ( $\pm 5^\circ\text{C}$ ).  
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Nevertheless, depending on the intended application, this cycle can be optimized, e.g. to 30 minutes at 100°C.

The stripping composition of the invention is liquid and it is applied to the surface of the mold at very small thickness (generally of the order of one  
35 micrometer), preferably by hand, using a cloth or by means of wipes pre-impregnated with the composition.

Generally, it is not necessary to apply the composition to the mold for each molding operation. The number of molding operations that are possible using a coating of the composition of the present invention  
5 depends on the type of molding that is performed, and it generally remains equivalent to that obtained with usual stripping compositions based on solvent.

It should be observed that the stripping composition of the invention is effective for polymerizing any  
10 composite part in molds made of metal or of composite material, using epoxy resins of a class less than or equal to 180°C.